



Technical Data Sheet

HLSF 90246 PC073 Clear

Description:	<i>HLSF90246, PC073 Clear</i> is a thermosetting powder coating based on a blend of epoxy and polyester. Hybrids are designed for interior applications where exterior durability is not required.	
Typical Applications:	Decorative finishes	
Typical Physical Properties:	Film Thickness (ASTM D)	2.0 – 3.0+ mil
	Gloss 60°angle (ASTM D-523-89)	90+
	Hardness (ASTM D-3363-92A)	2H
	Flexibility (ASTM D-1737-89)	1/8 inch
	Adhesion (ASTM D-3359-95A)	5B (100%)
	Impact Direct/Indirect (ASTM D-2794-93)	up to 160 in-lbs
	Exterior Durability	Poor
	Chemical Resistance	Poor
	Salt Spray (ASTM B117)	1000Hrs < 1/8"
	Specific Gravity	1.22±0.05
Application Data:	<i>HLSF90246, PC073 Clear</i> is to be applied with a corona electrostatic powder spray gun at between 60kv – 100 kv. Hybrids can also be formulated for tribo or fluid bed application upon request.	
Cure Schedules:	<i>HLSF90246, PC073 Clear</i> can be cured in a direct or indirect gas convection oven, an electric oven, or an Infrared. A combination of any of these ovens is also suitable.	
	Standard Cure: 10 Minutes @ 340°F Peak Metal Temperature	
Storage:	Product should be stored at temperatures below 80°F, in a dry area away from any heat source.	
Notes:	All tests were performed on Bonderite 1000, iron phosphated panels with a nominal film thickness of 2 mils. Please refer to the MSDS for safety information.	

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